



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.1512
Job Sheet 212182



Part No: 647.1512

Job Qty: 3 pcs

Part Name: Breakaway Tip



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/12/20

Job Tracking No:

Due Date: 9/4/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: 647.1500 REV.E IPP REV: A NEW ISSUE JFS 14/08/20 VERIFIED BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier	Sign-off
					Setup Run Hrs Hrs		
100	Bandsaw - 1	3 pcs	8/20/20	8/20/20	0.00 0.00	Bandsaw - 1	✓ 20-9-2
110	HAAS 4 Axis - B4B	3 pcs	8/21/20	8/21/20	1.00 0.75	HAAS - 1 - B4B	
						HAAS - 2 - B4B	
						HAAS - 3 - B4B	✓
						HAAS - 4 - B4B	
120	QC 2	3 pcs	8/21/20	8/21/20	0.00 0.00	QC 2 - 1	
						QC 2 - 12	
						QC 2 - 14	
						QC 2 - 17	
						QC 2 - 19	
						QC 2 - 2	
						QC 2 - 20	
						QC 2 - 22	
						QC 2 - 23	
						QC 2 - 25	✓
						QC 2 - 32	
						QC 2 - 33	
						QC 2 - 35	
						QC 2 - 39	
						QC 2 - 4	
						QC 2 - 40	
						QC 2 - 44	
						QC 2 - 45	
						QC 2 - 48	
						QC 2 - 49	
						QC 2 - 50	
						QC 2 - 51	
						QC 2 - 52	
						QC 2 - 57	
						QC 2 - 62	
						QC 2 - 63	

DART
AEROSPACE
Container No: S298061
Part: 647.1512
Job No: 212182
Serial No/Batch: S298061
Revision: E
Inspector:
Exp Date:
Instructions: Various STC's
Date: 09/02/20

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				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
130	QC 8	3 pcs	8/21/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
140	Outsource - 4 - Anodize	3 pcs	9/4/20		ATG001-VC 10
150	Packaging 2-1 - Receive - B4B	3 pcs	9/4/20	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B

				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Packaging 2 - 37 - B4B	
155	QC 6	3 pcs	9/4/20	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
					QC 6 - 82
180	Packaging 3-1 - Stock - B4B	3 pcs 4 pcs MD	9/4/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
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					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B

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28
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190 QC 21 - SA	3 pcs <i>4 pcs M/L</i>	9/4/20	0.00 0.00	Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
				QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 9	
				QC 21 - SA - 77	

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Part Op 100 - Cut Blank at 8.600"

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB319 DWG REV: _____ FOLIO REV: _____ 2-
debur and break all sharp edges

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : 47021 1- Black Anodize as per Dwg
647.1500 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required

150 - (Receive & Inspect for Damage & Mat'l Certs)

155 - QC6- All purchased or subcontracted products

180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND
REV***

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S2.000X0.750	7075-T6S Sheet 2" Thick Plate X 0.75" Wide	2.1510 ft (.717 ea)	100-Bandsaw - 1	<u>5246097</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S2.000X0.750	2	11	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Breakaway Tip	0.130inches $\pm$ 0.010	0.140 0.120		
2	Breakaway Tip	45.000degrees $\pm$ 0.500	45.500 44.500	Angle	
3	Breakaway Tip	4.910inches $\pm$ 0.010	4.920 4.900		
4	Breakaway Tip	4.098inches $\pm$ 0.005	4.103 4.093		
5	Breakaway Tip	1.341inches $\pm$ 0.005	1.346 1.336		
6	Breakaway Tip	0.250inches $\pm$ 0.010	0.260 0.240	Radius	
7	Breakaway Tip	0.188inches $\pm$ 0.005 - 0.001	0.193 0.187	Diameter	
8	Breakaway Tip	0.129inches $\pm$ 0.005 - 0.001	0.134 0.128	Diameter	
9	Breakaway Tip	0.380inches $\pm$ 0.010	0.390 0.370		
10	Breakaway Tip	0.580inches $\pm$ 0.010	0.590 0.570		
11	Breakaway Tip	0.375inches $\pm$ 0.002 - 0.000	0.377 0.375		
12	Breakaway Tip	0.101inches $\pm$ 0.002	0.103 0.099		
13	Breakaway Tip	1.500inches $\pm$ 0.002	1.502 1.498		
14	Breakaway Tip	0.760inches $\pm$ 0.010	0.770 0.750		
15	Breakaway Tip	0.320inches $\pm$ 0.005	0.325 0.315		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB047021



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB047021

PO Date: 9/3/20

Due Date: 9/18/20

Purchase Order

Revision:

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	211270	D1038-58B	D1038 Rev B	Avionics Fastener Rail : Various STC's Issue P/O: Black Anodize as per Dwg D1038 and QSI 017 4.1.10 Anodize per MIL-A-8625F Type I or IB or IC or II or IIB Class 2, Type III Class 2	Firmed X40	-	9/18/20	40 pcs	0 pcs	40 pcs	\$4.89/pcs	\$195.60
2	212428	649.5011	649.5000 Rev D	Deflector : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed X8	-	9/10/20	8 pcs	0 pcs	8 pcs	\$12.14/pcs	\$97.12



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PURCHASE ORDER
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Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	212429	649.5214	649.5200 Rev C	Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N	Firmed X10	-	9/10/20	10 pcs	0 pcs	10 pcs	\$10.64/pcs	\$106.40 NE
									SEP 17 2020			
4	212435	649.4813	649.4800 Rev E	Shim : Various STC's Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) ISSUE P/O: As Per MPP-172 Section 2.1, Hard Anodize IAW MIL-A- 8625, Type III, Class 2, Color Black As Per MPP-172 Section 4.2 Prime IAW MIL-P- 23377J Type1 Class N	Firmed X10	-	9/10/20	10 pcs	0 pcs	10 pcs	\$7.89/pcs	\$78.90 NE
									SEP 17 2020			
5	212182	647.1512	647.1500 Rev E	Breakaway Tip : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : 1- Black Anodize as per Dwg 647.1500 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Comformity is required	Firmed X4	-	9/10/20	4 pcs	0 pcs	4 pcs	\$12.34/pcs	\$49.36 NE
									SEP 17 2020			

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PURCHASE ORDER

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Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	212475	649.4811	649.4800 Rev E	Clip : Various STC's Issue P/O: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N Certification of Conformity is required	Firmed	-	9/10/20	4 pcs	0 pcs	4 pcs	\$11.24/pcs	\$44.96
SEP 17 2020												
Grand Total:												
\$572.34												

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Please ensure to send the related invoice to hby_ap@dartaero.com.

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 920808

Date: 14-Sep-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.			
8 ea	Part: 649.5011 Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 5526778 Job: 28084 PO: POHB047021	Rev: D	Expiry Date: 8/23/21 Line: 2
4 ea	Part: 647.1512 Breakaway Tip Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 5526778 Job: 28087 PO: POHB047021	Rev: D	Expiry Date: 8/23/21 Line: 5
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>SEP 14 2020</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Made in Canada.			

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RECEIVED
SEP 16 2020
DART AEROSPACE LTD.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 920808

Date: 14-Sep-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.		
Made in Canada.			